

Date: Tuesday, 7/10/2007 1:05:44 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	PLUG
Job Number	33450		
Estimate Number	10178		
P.O. Number	N/A	Part Number	D25941
This Issue	7/10/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2594 REV C
First Issue	N/A	Project Number	N/A
Previous Run	32651	Drawing Revision	C
Written By		Material	N/A
Checked & Approved By	<u>John</u> 07.10	Due Date	7/23/2007
Comment	Est D 02.08.22 Make in Cobra KJ est E 06.12.11 ecn 836 EC	Qty:	500 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6R0625	6061-T6 Round Bar .625"	
		Comment: Qty.: 0.0547 f(s)/Unit Total : 27.3525 f(s) Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625)	28.5' 20 07/11/08
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL 1-Make as per Dwg D2594-1 and Folio FA262. 2-Break all sharp edges 0.010 max.	DIP 07/11/07 20 07/11/08
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	DIP 07/11/07 20 07/11/08
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	25 07/11/08
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Acid etch and alodine as per QSI 005 4.1	25 07/11/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/10/2007 1:05:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 33450

Part Number: D25941

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 POWDER COATING

POWDER COATING



m/105914



516

Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)

FL 07/11/14

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



516x

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-f

07/11/14

8.0 PACKAGING 1

PACKAGING RESOURCE #1



516x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP 8

m-f 07/11/14

9.0 QC21

FINAL INSPECTION/W/O RELEASE



516

Comment: FINAL INSPECTION/W/O RELEASE

D 07/11/15

Job Completion



u 07.11.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33450
Description: Plug	Part Number:	D2594-1
Inspection Dwg: D2594	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	DJP	Audited by:	owl	Prototype Approval:	N/A
Date:	07/11/07	Date:	07/11/07	Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	
B	06.12.20	Dwg Rev. updated	KJ/JLM	JL

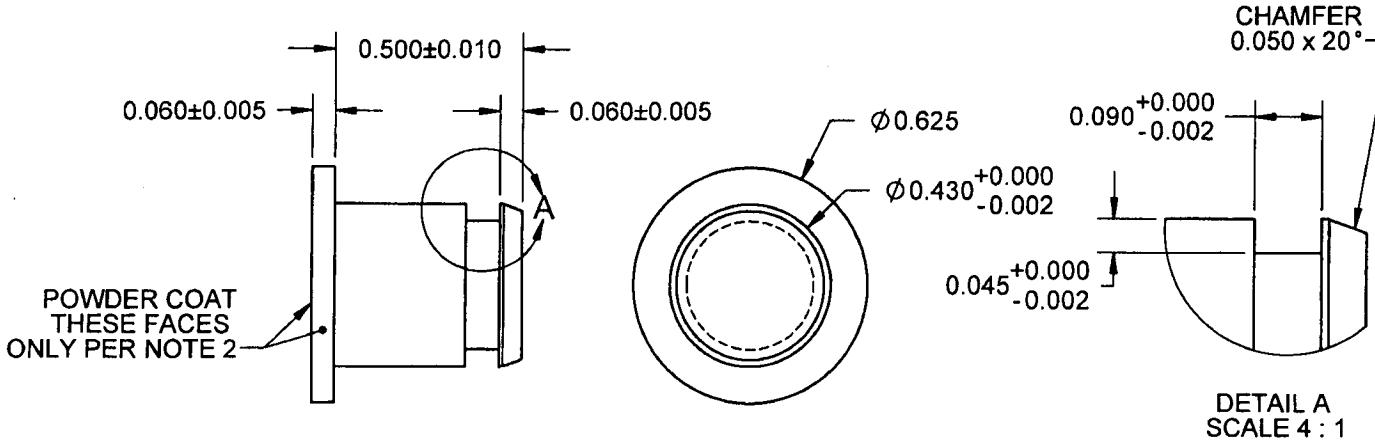
DART

DESIGN <i>CH</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>CH</i>	DRAWING NO. D2594	REV. C SHEET 1 OF 1
DATE 06.11.20		TITLE PLUG	SCALE 2:1

PRINT RELEASED BY DART AEROSPACE LTD

06.11.28 - *CH*

REV	DATE	DESCRIPTION
A	96.09.16	NEW ISSUE
B	97.03.15	ADD GROOVE AND O-RING
C	06.11.20	ADD PWDR COAT; ADD MS P/N TO D2594-3; ADD AMS SPECS; ADD TOLERANCE NOTE



D2594-1 PLUG

D2594-1 PLUG NOTES:

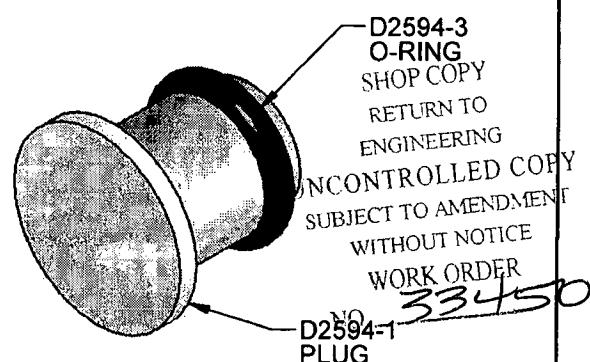
- 1) MATERIAL: ALUMINUM 5052-H32 ROUND BAR PER QQ-A-225/7 (REF DART SPEC M5052H32R) OR ALUMINUM 6061-T6/T651/T6510/T6511/T62 ROUND BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116/4160 (REF DART SPEC M6061T6R)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SPECIFIED FACES WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES TO 0.010 MAX

D2594-3 O-RING NOTES:

- 1) 5/16 ID, 7/16 OD, 1/16 WIDTH
- 2) POSSIBLE SUPPLIER P/N: PARKER 2-011 OR MS28775-011

PARTS LIST:

QTY	P/N	DESCRIPTION
X	D2594	PLUG ASSEMBLY
1	D2594-1	PLUG
1	D2594-3	O-RING



D2594 PLUG ASSEMBLY

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